Work Order ID Thursday, April 21, 2011											Page 1
Item ID: D3255- Revision ID: Item Name: Gasket	5	·	Accept		1111 11511 1111				Start Stop		
Start Date: 4/20/20 Required Date: 4/25/20 Reference:	~ .			Cust Item II Customer:	D:						ete (1 <b>.6</b> 11 <b>5</b> ) 1 <b>55</b> )
Approvals: Proces QC: _	ss Plan:	Date://_04_3	/ Tooling:		te:				Start Stop		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									•	
D3255	Rev B										
Waterjet FLOW CNC Waterjet	FLOW WATER JET  Memo 1-Cut as if necess	per Dwg D3255□Dwg Rev:_ ary	0.00 0.00 В □Prog Rev: \	□2-Deburr			1311-	·5-5		(7)	
110 QC Quality Control	QC2- Inspect parts of Memo	ff machine FAI/FAIB	0.00				1811	<u> </u>			
120 	QC8- Inspect parts -	second check	0.00 0.00 E W	ustos			_(Hi	シ			

Quality Control

Dart Aerospace	• Ltd	
----------------	-------	--

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CH	ANGE	E	Зу	Date C	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cat	egory:	_ NCR:	Yes N	o DQA:		_ Date: _	
	R	esolution:	Disposit	on:	QA: N	/C Clos	sed:		Date:	
NCR:			VORK ORI	PER NON-CONFORMA	ANCE (	NCR)				
DATE	STEP	Description of NC		<u>*                                      </u>	ion B		Verificat	ion	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description  Chief Eng		Sign & Date	Section	С	Chief Eng	QC Inspector
										,

## Work Order ID 68783



Page 2

Thursday, April 21, 2011 8:50:28 AM

Item ID:

D3255-5

**Revision ID:** Gasket Item Name:

**Start Date:** 

4/20/2011

Start Qty: 6.00 **Required Date: 4/25/2011** 

Operation

Description

Req'd Qty: 6.00

**Customer:** 

Tool ID

**Cust Item ID:** 

Date:

Date:

Tool # Plan

Code

Reference:

Approvals:

Sequence ID/

Work Center ID

Process Plan:

Date:\_\_\_\_

Date:

Accept

**SPC (Y/N):** 

**Tooling:** 

Set Up/ Run Hours

Identify as per dwg & Stock Location: SMA

Memo

0.00

Packaging Packaging

140

130

**Quality Control** 

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

Reject

Accept Qty

Qty

Run

Setup Start

Stop

Start

Stop

Reject

Number

Stamp

Insp.

Dart Aerospace Ltd	C	)art	Aer	osp	ace	Ltd
--------------------	---	------	-----	-----	-----	-----

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CH	ANGE	E	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	<u>                                     </u>	PAR #:	Fault Cat	egory:	NCR·	Yes N	o DQ	۸.	Date:	
		esolution:		i					•	
NCR:			WORK OR	ER NON-CONFORM	ANCE (	NCR)		• • •		
DATE	STEP	Description of NC			tion B		Verific	ation	Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Section		Chief Eng	QC Inspector
									-	

# **Picklist Print**

Thursday, April 21, 2011 8:50:34 AM

Work Order ID: 68783

Parent Item:

D3255-5

Parent Item Name: Gasket



Start Date: 4/20/2011

Required Date: 4/25/2011

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP □A□04.05.12□New issue□KJ/RF

IPP Rev:B Now On Waterjet 06-08-14 JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255		Manufactured	No			110	sf	49.0000	1.5411	9.733263	12.		
					ı					1311-	5-5		
Gasket					,					1311-	5-5		

Location	Loc Qty	Loc Code	
ST412	49		
63846	49		63846

# **Dart Aerospace Ltd**

W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PROC	CEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							7 Tod Mgi	
******								
Part No	•	PAR #:	_ Fault Cat	egory:	_ NCR: Yes	No DQA:	Date: _	
	R	esolution:	_ Dispositi	on:	_ QA: N/C Clo	osed:	Date: _	
NCR:		W	ORK ORI	ER NON-CONFORMA	NCE (NCR	)		
DATE	STEP	Description of NC	Initial	Corrective Action Section	on B Sign &	Verification	Approval	Approval
-7		Section A	Chief Eng	Action Description Chief Eng	Date	Section C	Chief Eng	QC Inspector
					-			
					-			
					į			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	48783
Description: Gasket	Part Number:	D3255-5
Inspection Dwg: D3255 Rev: B		Page 1 of 1

	FIRST	ARTICLE IN	SPECTION	ON CHE	CKLIST		
	X	First Artic	ele 🗀	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
1.00	+/-0.030	,999	४		V 1802		
18.46	+/-0.030	18.46	+		T 1801		
11.43	+/-0.030	11.43	6		7		
15.36	+/-0.030	15.36	U		T		
6.90	+/-0.030	6.90	8		7	-	
0.063	+/-0.010	, 060	>		V		
			_				
							·
							<del></del>
						_	
		***					
						<u> </u>	
easured by:		Audited by:	$\mathcal{L}$	,	Prototype Ap	oproval:	N/A
- 1	. 5-7	Date:	110/	26		Date:	N/A
ev Date C	hange				Rev	ised by	Approved

Rev	Date	Change	Revised by	Approved
Α	07.07.18	New Issue	KJ/JLM J	B

Dart /	Aeros	pace	Ltd
--------	-------	------	-----

W/O:			W	ORK ORDER	RICHANGES					
DATE	STEP	PRO	CEDURE CHANGE By Date Qty				Qty Approval Chief Eng / Prod Mgr QC		Approval QC Inspector	
										t.
								!		
Part No:		PAR #:	Fault Cat	egory:	N	CR: Yes	No <b>DQ</b>	<b>A</b> :	_ Date: _	· · · · · · · ·
	R	esolution:	Dispositi	on:	Q	A: N/C C	losed:		Date:	
NCR:		\	WORK ORE	DER NON-CO	NFORMANC	E (NCI	₹)			
DATE	STEP	Description of NC		Corrective Ac	<u>*                                      </u>		Verifi	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng		escription Eng	Sign Date		ion C	Chief Eng	QC Inspector
,								<u> </u>		
									t t	
ı		,								
·										
•										

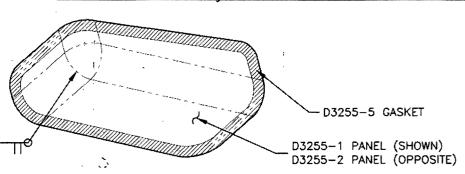


DESIG	N T	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANAL	
CHECK	(ED	APPROVED	DRAWING NO.	REV. B
	W	- H-	D3255	SHEET 1 OF 4
DATE			TITLE	SCALE
04.1	2.06		ACCESS PANEL ASSEMBLY	1:6
A		04.01.27	NEW ISSUE	

D3255-3 REDESIGN; ADDED Ø0.098

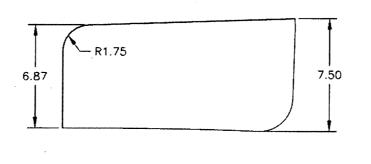


WELD D3255-3 -

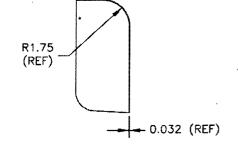


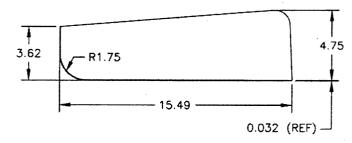
04.12.06

#### D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)



В





SHOP COPY RETURN TOENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

0/11-04-21

D3255-1 BEND DETAIL D3255-2 OPPOSITE

#### D3255-041/-042 NOTES:

WELD PER DART QSI 004

FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS

4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

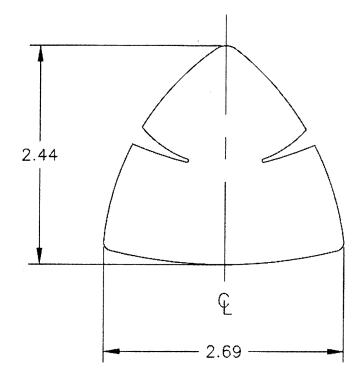
Dart	<b>Aeros</b>	pace	Ltd
------	--------------	------	-----

	•				B .								
W/O:			W	ORK ORDER	CHANGES								
DATE	STEP	PRO	OCEDURE CHA	IANGE By Date   Qty   Chi		By D			By Date Qty		By Date Qty Approval Chief Eng / Prod Mgr QC I		Approval QC Inspector
							·,··						
Part No	:	PAR #:	Fault Cate	egory:	N	CR: Yes	No DQ	A:	Date: _	<del> </del>			
	Re	esolution:	Disposition	on:	QA: N/C Closed				sed: Date:				
NCR:			WORK ORD	ER NON-CO	NFORMANC	E (NCF	R)						
		Description of NC	Description of NC Corrective Action			verificatio			Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action De Chief	scription Eng	Sign 8 Date		tion C	Chief Eng	QC Inspector			
									İ				
				<b>,</b>									
				İ									
	1						}						



DESIGN	DRAWN BY		ROSPACE LTD PY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. B
1 4	#	D3255	SHEET 2 OF 4
DATE	-,- <del></del>	TITLE	SCALE
04.12.06		TITLE	1:1





D3255-3 CAP FORM TO FIT D3155-1/-2



### D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED:
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

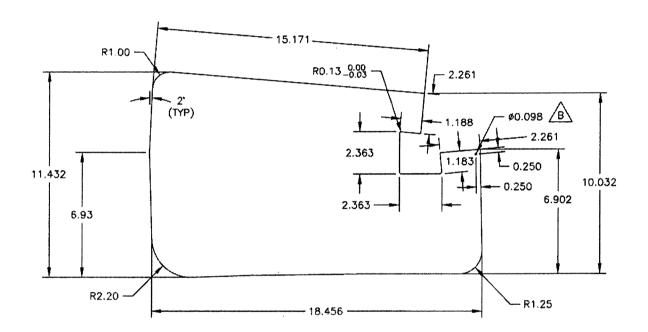
Dari Aerospace Lic	erospace L	td
--------------------	------------	----

W/O:			W	ORK ORDER	CHANGES					,		
DATE	STEP	PRO		CEDURE CHANGE By Da			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	•	PAR #:	Fault Cat	egory:	NC	R: Yes I	No DQA	\:	Date:			
	Re	esolution:	Dispositi	Disposition: QA: N/C Close				sed: Date:				
NCR:		\	WORK ORE	DER NON-CO	NFORMANCE	(NCR)	)					
		Description of NC		<u>#</u>		ction B Verific		ation	ion Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action De Chie	scription Eng	Sign & Date	Section C		Date Section C		Chief Eng	QC Inspector
	1	1	1 1	F		I .	1		1	1		



DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHECKED	APPROVED	DRAWING NO.	REV. B SHEET 3 OF 4
DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5





u 10 48783

#### D3255-1/-2 FLAT PATTERN

#### D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

Copyright © 2004 by DART AEROSPACE LTD

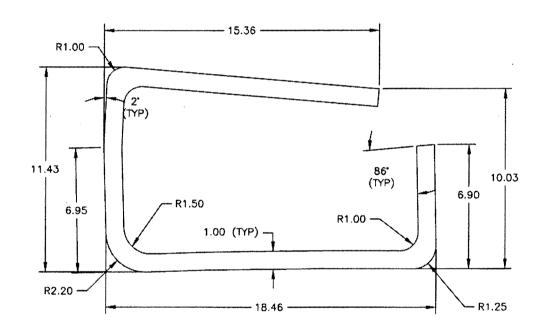
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

		· · · · · · · · · · · · · · · · · · ·			#											
W/O:			W	ORK ORDER	CHANGES											
DATE	STEP	PRO	PROCEDURE CHANGE By Date		PROCEDURE CHANGE By Date		PROCEDURE CHANGE By Date		PROCEDURE CHANGE		NGE By D			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									,							
Part No	:	PAR #:	Fault Cate	egory:	NO	CR: Yes	No <b>DQ</b>	A:	Date: _							
	R	esolution:	Dispositio	n:	Q.	A: N/C CI	osed:		Date:							
NCR:		V	WORK ORD	ER NON-CC	NFORMANC	E (NCR	<b>l</b> )			_						
DATE	STEP	Description of NC				Section B Verificati				Approval						
DAIL	O I E I	Section A	Initial Chief Eng		Eng Eng	Date	Secti	on C	Chief Eng	QC Inspector						
										. `						
						<u> </u>										
	1															



DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAN	
CHECKED	APPROVED	DRAWING NO.	REV. 8
1 4	1	D3255	SHEET 4 OF 4
DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5





D3255-5 GASKET

u/068283

#### D3255-5 NOTES:

1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16 POSSIBLE SUPPLER: AVIALL

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES

Copyright @ 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospac	e	Ltd
---------------	---	-----

				F .						
W/O:			W	ORK ORDER CH	ANGES					
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector	
				·						
Part No:		PAR #:	_ PAR #: Fault Category:			NCR: Yes No DQA: Date:				
	R	esolution:	Dispositio	n:	QA: N/C	QA: N/C Closed:			·	
NCR:		V	VORK ORD	ER NON-CONFO	RMANCE (NO	CR)				
DATE	STEP	Description of NC	Corrective Action		Section B	Ve	rification	Approval	Approval	
		Section A	Chief Eng	Chief Eng	Da		Section C	Chief Eng	QC Inspector	
						į				
				}						